

Date: Friday, 15/05/2009 1:54:17 PM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE, ANCHOR
Job Number	: 47982		
Estimate Number	: 13935		
P.O. Number	:	Part Number	: D3948043
This Issue	: 15/05/2009 S.O. No. :	Drawing Number	: D3948 PROTO
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : R & D SM/MED FAB	Drawing Revision	: PROTO 09-05-15
Previous Run	:	Material	:
Written By	:	Due Date	: 22/05/2009 Qty: 8 Um: Each
Checked & Approved By	: MF 09-05-15		
Comment	: Est Rev:A 08-09-18 new issue DD verified by:EC		

## Additional Product

# PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.0200 sf(s)/Unit Total : 0.1596 sf(s)  
 6061-T6 .040 Sheet  
 batch: 109396 B 9-5-19

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3948-3  
 Dwg Rev: PROTO  
 Prog Rev: TYPE B 9-5-19

9

2-Deburr if necessary

SB

09/05/19

9

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

CP 09.05.20

9

5.0	SMALL FAB	SMALL & MEDIUM FAB RESOURCE 1
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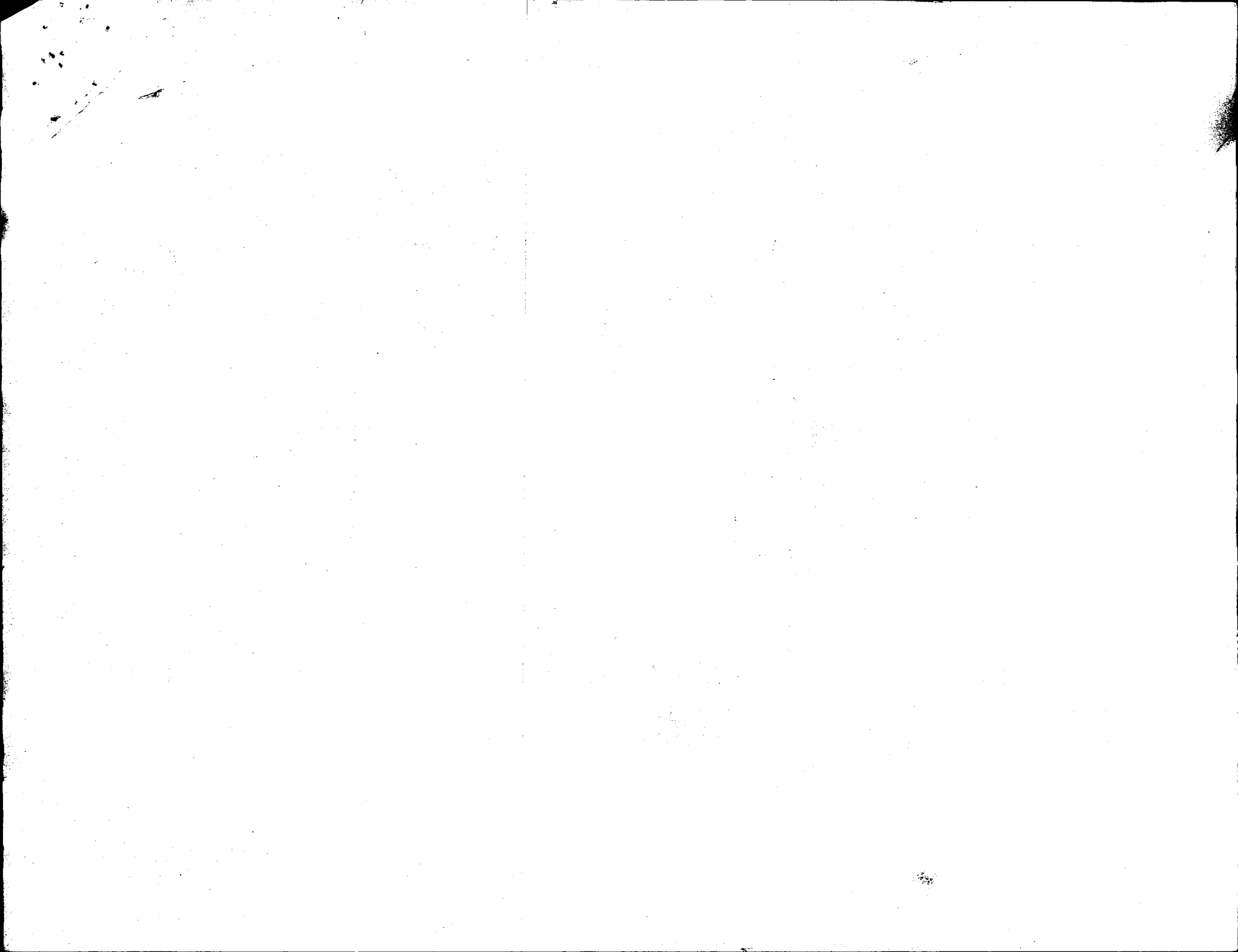


Comment: SMALL & MEDIUM FAB RESOURCE 1

1-countersink holes as per dwg

2-deburr if necessary

09/05/21 9



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Part Number: D3948043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg

SB 09/05/21

(9)

7.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

CP 09.05.21

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

CP 09.05.21

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

CP 09.05.21

10.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut Plate

batch: M109962

CP 09/05/21

11.0

MS20426AD323

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

RIVET

batch: M 7681

CP 09/05/21

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install anchor nuts and rivets as per dwg

CP 09/05/21 (9)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CP 09.05.21



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Job Number: 47982

Part Number: D3948043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock  
Location: \_\_\_\_\_

ENG USE ONLY

09.05.21

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09.05.22 Prototype

Job Completion



00280A

MF 09-06-09



# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D350-766

Job #: 00280A

Date: 09.05.15

Product Name: 350 Baggage Protectors

Requested By: CP

Design Manager Approval: [Signature]

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
3	D3948-041	SF	PLATE, ANCHOR	09.05.15	Y	ASAP		
4	D3948-043	SF	PLATE, ANCHOR	09.05.15	Y	ASAP		
3	D3948-1	SF	PLATE	09.05.15	Y	ASAP	No finish required, assembled in D3948-041	
4	D3948-3	SF	PLATE	09.05.15	Y	ASAP	No finish required, assembled in D3948-043	

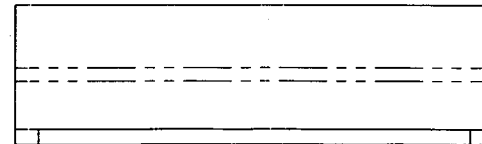
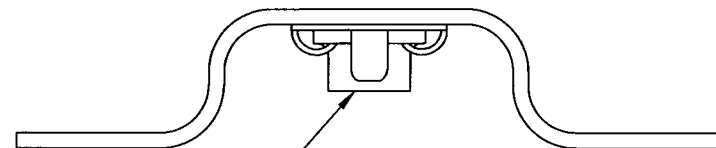
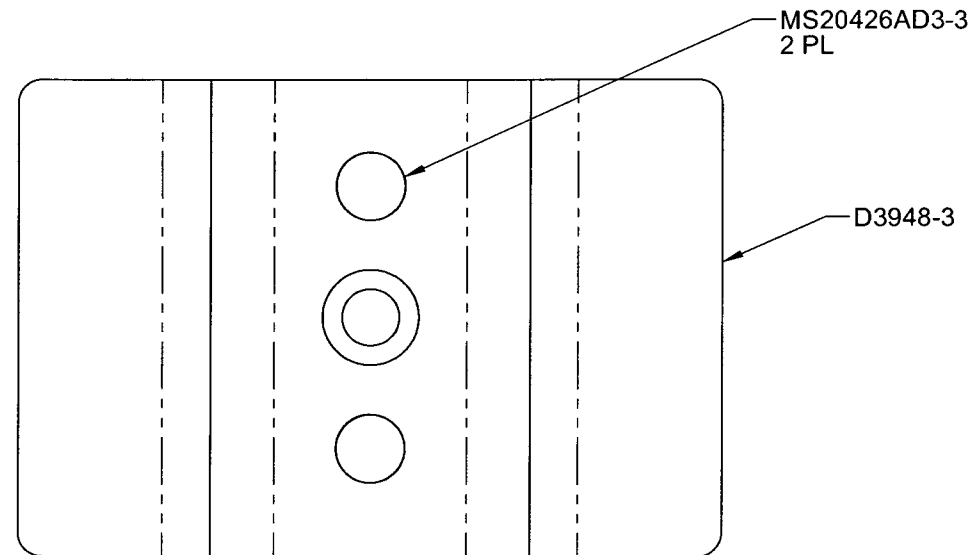
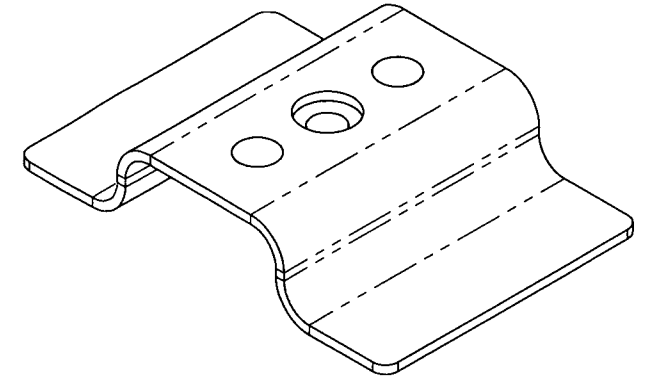




## PARTS LIST

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3948-043	PLATE, ANCHOR
2	1	D3948-3	PLATE
3	1	MS21059L3	NUTPLATE (OR MS21059-3)
4	2	MS20426AD3-3	RIVET

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
*GP* 09.05.13



**D3948-043 PLATE, ANCHOR**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>GP</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>GP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3948</b>	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>PLATE, ANCHOR</b>	NTS
DATE	<b>09.05.13</b>	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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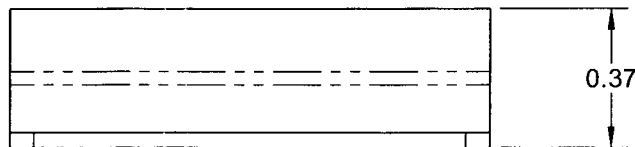
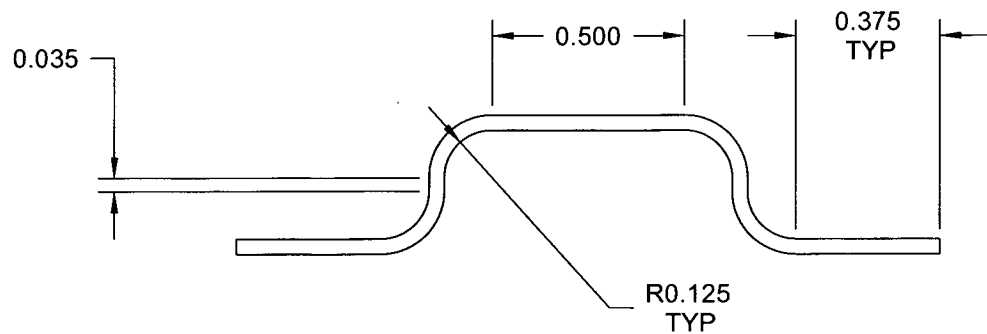
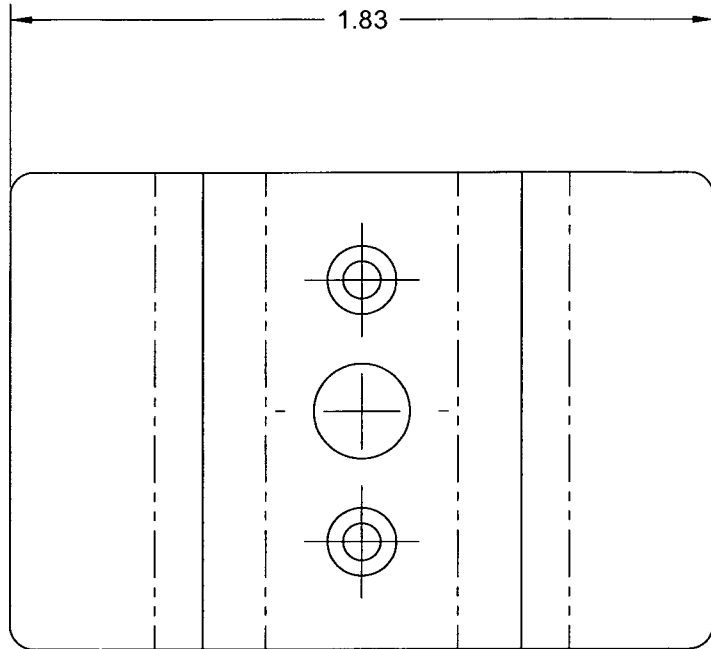
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C

B

A

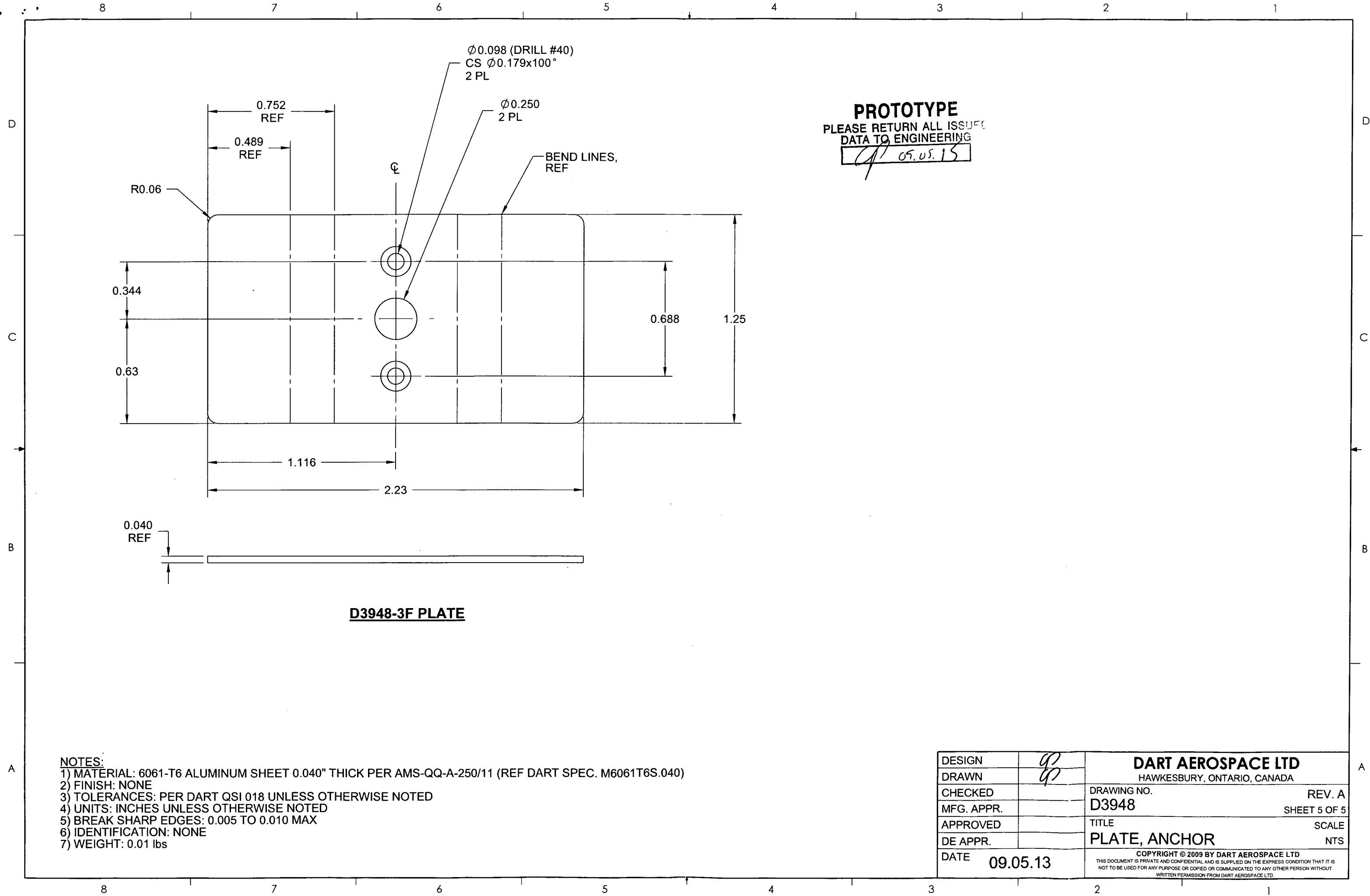
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**D3948-3 PLATE**

- NOTES:**
- 1) MATERIAL: MAKE FROM D3948-3F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 004 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-3" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.01 lbs

DESIGN	gp	<b>DART AEROSPACE LTD</b>	
DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3948</b>	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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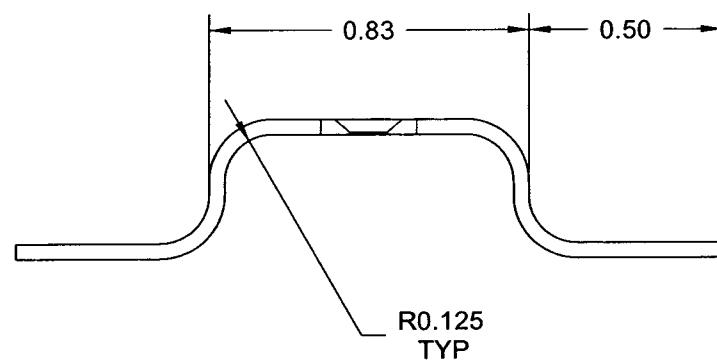
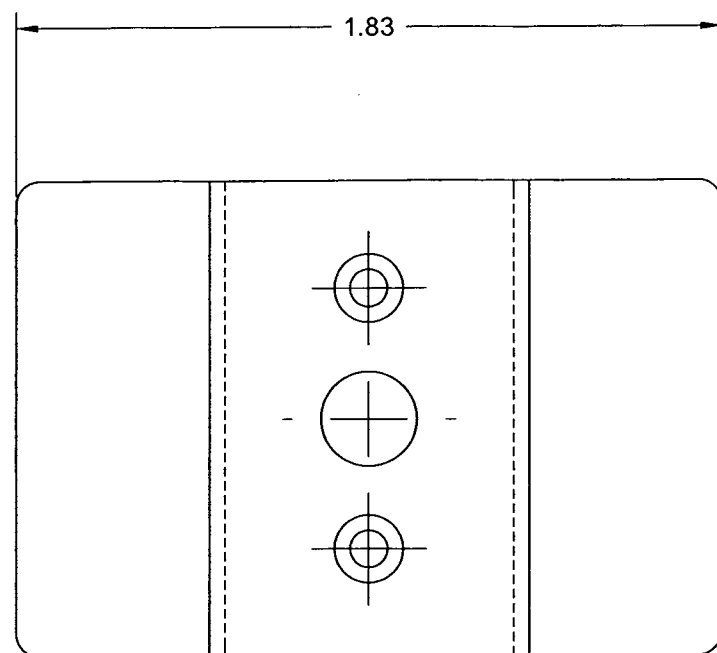


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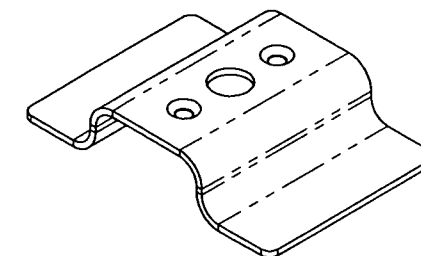
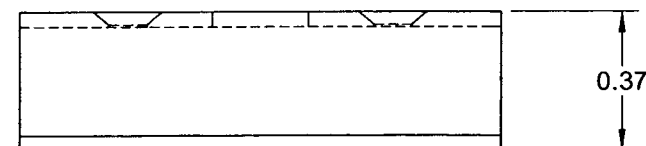
**D3948-3F PLATE**

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER AMS-QQ-A-250/11 (REF DART SPEC. M6061T6S.040)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.01 lbs

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3948</b>	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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DRAWN			
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MFG. APPR.		<b>D3948</b>	SHEET 4 OF 5
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